

CLAIMS

1. Generally disc-shaped token (10) of the type having a body (12) produced by multiple injection of plastic material, the token comprising at least:

5 - a generally disc-shaped core (14) of the body of the token produced by a first injection of plastic material and having a central portion (24) defining the central portion of the body of said token and a peripheral portion (31) defining at least part of the edge (20) of said body of the token; and

10 - a covering layer (16) produced by a second injection of plastic material around the peripheral portion (31) of the core (14) to produce in conjunction with the core all or almost all of the edge (20) and of the annular peripheral portion (17) of the body (12) of the token, which is characterized in that the core (14) of the token incorporates an insert (26) embedded in the plastic material of the central portion of said body during the first injection and including a contactless electronic microchip identification device (27).

15 2. Token (10) according to claim 1, characterized in that in the first injection the core (14) defines at least part of the annular peripheral portion (17) of the body (12) of the token.

20 3. Token (10) according to claim 2, characterized in that in the first injection the core (14) defines at least part of the annular peripheral portion (17) of the token and the edge (20) of the token by way of radial peripheral projections (18) that may be grouped or not, are preferably evenly distributed in the circumferential direction and extend on either side of said body (12) and axially over the edge (20).

25 4. Token (10) according to any one of claims 1 to 3, characterized in that in conjunction with the core said covering layer (16) defines the annular peripheral portion and the edge of the body of the token except for housings (19) provided with injected plastic material edge inclusions produced by at least one complementary injection.

30 5. Token (10) according to any one of the preceding claims, characterized in that the peripheral region of the central portion of the core includes a plurality of openings (36) into which project portions of the insert (26) including said electronic microchip identification device (27).

35 6. Token (10) according to claim 5, characterized in that the core (14) includes at least three openings (36) evenly distributed in the circumferential direction at the periphery of the central portion (24) of the core.

7. Token (10) according to either claim 5 or claim 6, characterized in that

said portions of the insert (26) projecting through openings (36) in the core (14) are sufficiently strong to hold the insert (26) in place during injection of the core of the body of the token.

5 8. Token (10) according to any one of claims 5 to 7, characterized in that the center of the central portion (24) of the core has at least one recess (46) on at least one of its faces.

10 9. Token (10) according to any one of claims 5 to 8, characterized in that the internal portion of said annular peripheral portion of the core (14) includes a circular groove (22) including through passages (34) that are preferably evenly distributed in the circumferential direction.

10 10. Token (10) according to any one of claims 5 to 9, characterized in that said openings (36) and/or any recesses (46) in the faces of the token and/or said through passages (34) are filled with plastic material by said second injection.

15 11. Token (10) according to any one of the preceding claims, characterized in that the body (12) of the token has on each face a cavity (15) into which is fixed a label (22) carrying a decoration and/or a mark and/or a hologram.

12. Token (10) according to any one of the preceding claims, characterized in that it is produced by injecting plastic materials of different colors.

20 13. Method of fabricating a body (12) of a token (10) according to any one of the preceding claims, comprising at least the following operations:

25 - placing an insert (26) including a contactless electronic microchip identification device (27) in a first injection mold (42) two half-shells (41, 43) whereof define a first imprint corresponding to a generally disc-shaped core (14) of the body of the token;

25 - holding said insert (26) at the center of the first imprint by axially clamping it between the two half-shells (41, 43) of the first mold;

- injecting the core (14) of the token;

30 - placing the core (14) of the token in a second injection mold, two half-shells whereof define a second imprint corresponding to the whole or almost the whole of the body (12) of the token;

- holding said core (14) at the center of the second imprint by axially clamping the central portion (24) of the core between the two half-shells of the second mold;

- injecting the covering layer (16);

35 - where applicable, further injection(s) of edge inclusions to complete the

body of the token, if necessary; and

- optionally machining the body (12) of the token to finish the edge (20) of the token.

5 14. Fabrication method according to claim 13, characterized in that the clamping during the first injection and/or the second injection is realized at the peripheral area of the central portion (24) of the core (14) of the token.

15. Generally disc-shaped token (50), characterized in that:

10 - it includes a body (52) produced by a single injection of plastic material incorporating an insert (66) that is buried during injection in the plastic material of the central portion (64) of said body and including a contactless electronic microchip identification device;

- the periphery of the central body portion (64) includes a plurality of openings (76) into which project portions of the insert (66) including said electronic microchip identification device; and

15 - said portions of the insert (66) projecting through said openings are sufficiently strong to hold the insert (66) in place during injection of the body of the token.

20 16. Token (50) according to claim 15, characterized in that the central portion (64) of the body of the token has on each face a cavity (55) in which is disposed and fixed a label (62) carrying a decoration and/or a mark and/or a hologram.

17. Token (10, 50) according to any one of claims 1 to 12, 15 and 16 using colored plastic materials obtained from at least one basic polymer selected from:

25 - polymethyl methacrylate (PMMA);
- acrylonitrile-butadiene-styrene (ABS);
- polyamides and copolymers thereof;
- polyacetal and acetal copolymers (POM/polyoxymethylene);
- phenylene polysulfide (PPS);
- polyalkylene terephthalates, in particular polybutylene terephthalate (PBT);
30 - thermoplastic polyurethanes (PUR);
- vinyl polymers, polyvinyl chloride (PVC);
- polyolefins, in particular polyethylenes (PE) and polypropylenes.

35 18. Generally disc-shaped token (10, 50) according to any one of claims 1 to 12 and 15 to 17, characterized in that it comprises a body (12, 52) produced by injection of plastic material and having a diameter greater than or equal to 39 mm

and a maximum thickness that does not exceed 3.3 mm, the thickness of the central portion (24, 64) of the body being of the order of 2.5 mm.

19. Token (10, 50) according to any one of claims 1 to 12 and 15 to 18, characterized in that it constitutes a gaming chip or a casino chip.